

Work Order ID 63332

Wednesday, October 27, 2010 3:51:01 PM

Page 1

Item ID: D4155-1

Accept

Revision ID:

Item Name: Bar

Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/11/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-10-38 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4155

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: 1

Prog Rev: 1

2-Deburr if necessary

0.00

10-11-15

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

10-11-15

Photo ->

Scrap

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4155-1 PAR #: _____ Fault Category: Small Fob / w-Jet NCR: Yes No DQA: _____ Date: 10/11/17
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 10/11/17 Date: 10/11/17

NCR: <u>03332</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10-11-16</u>	<u>110</u>	<u>finish & shape</u> <u>Not acceptable</u> <u>R.C. Damaged material.</u>	<u>U</u> <u>10-11-16</u>	<u>Scrap / Destroy</u>	<u>10/11-16</u>	<u>S</u> <u>10/11/16</u>	<u>U</u> <u>10-11-16</u>	<u>S</u> <u>10/11/16</u>

NOTE: Date & initial all entries

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Page 2

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Required Date: 11/11/2010 Req'd Qty: 4.00

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Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Weld per dwg A/R Hardcoat steel Batch: _____

0.00



Large Fab

Memo

0.00

Large Fab

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Scrap

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

160



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Scrap

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

~~OK 10/27/10~~
MF
10-11-15

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 3:51:05 PM

Page 1

Work Order ID: 63332

Parent Item: D4155-1

Parent Item Name: Bar



Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.500X012.000		Purchased	No			100	f	2.9410	1.27	5.347368			
304 BAR .500 X 12.00													



B10-11-15

Location

Loc Qty

Loc Code

MAT53

2.941

112778

2.941

116061

(4)

Scrap

W/O:		WORK ORDER CHANGES					
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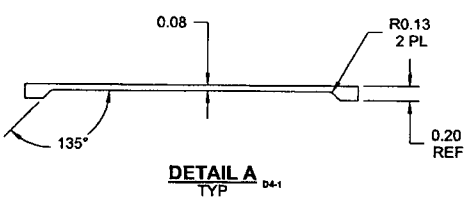
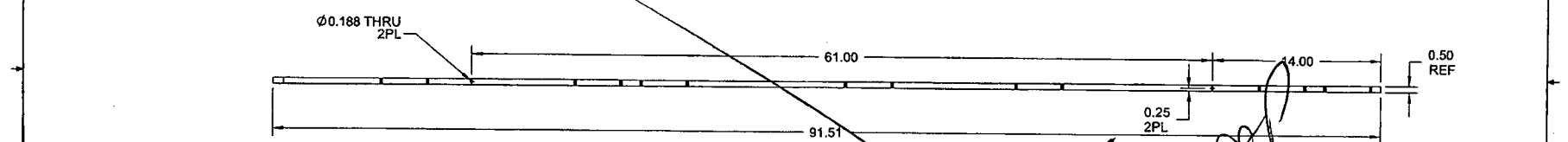
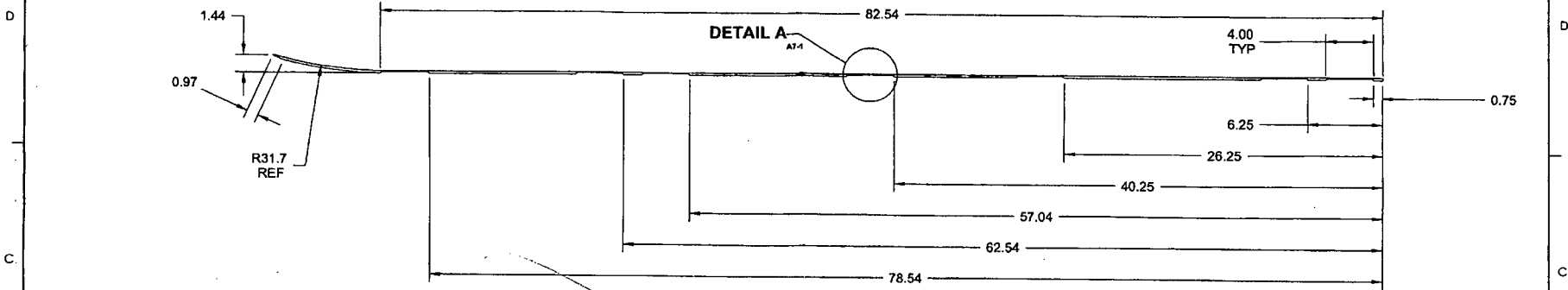
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4155-1 BAR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43332

Scrap

RELEASED
2010-09-15

- NOTES:
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK PER ASTM A276 (REF. DART SPEC. M304B)
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.16 lbs

A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4155	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
DATE	10.07.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

Bl 10-10-2d

8 7 6 5 4 3 2 1

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